

Work Order ID 106617-2

\*106617\*

Page 1

Wednesday, September 11, 2013 7:43:37 AM

Item ID: 647.0115

647.0115

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

B106617

Stop \*NS2\*

Item Name: Clip

71  
\*100\*  
\*100\*

Start Date: 9/11/2013 Start Qty: 100.00

Cust Item ID:

Required Date: 10/4/2013 Req'd Qty: 100.00

Customer:

Reference:

Approvals: Process Plan: *CL*

Date: 13/09/11 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.0100	A

0.00

0.00

0.00

0.00

DAS  
27  
9-89

B 10 16

110

\*110\*

Purchasing

Purchasing

Memo

Issue P/O: 21295  
Make 647.0115 as per Dwg 647.0100  
Possible Supplier: G.F.Y.  
Material release note is required

*ent*

QC6- Inspect dimensions to drawing

Memo

120

\*120\*

QC

Quality Control

*CL 13/09/11 100*

*13/1/16 (100)*

*100*

4365

# Work Order ID 106617

Wednesday, September 11, 2013 7:43:37 AM

\*106617\*

Page 2

Item ID: 647.0115

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Clip

Start Date: 9/11/2013 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 10/4/2013 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

160

Outsource process-Anodize per QSI017 4.1.10.1

0.00

\*160\*

Outsource4

Outsource process - Anodize

Memo

0.00

Issue P/O to ATG : 21743

1- Black Anodize as per Dwg 647.0100

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Comformity is required

CZ 13/10/18 100

170

Receive & Inspect for Damage & Mat'l Certs

0.00

\*170\*

Packaging

Packaging

Memo

0.00

13/12/2 (67) 45 CRAP

180

QC5- Inspect part completeness to step on W/O

0.00

\*180\*

QC

Quality Control

Memo

0.00

DAS  
27  
9-89  
13/12/17

67  
can

PTC





# Work Order ID 106617

Wednesday, September 11, 2013 7:43:37 AM

\*106617\*

Page 3

Item ID: 647.0115 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Clip  
 Start Date: 9/11/2013 Start Qty: 100.00 \*100\* Cust Item ID:  
 Required Date: 10/4/2013 Req'd Qty: 100.00 \*100\* Customer:

Reference:  
 Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <del>ST535</del>	0.00							
*210*		0.00							
Packaging	Memo								
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
220	QC21- Final Inspection - Work Order Release	0.00							
*220*		0.00							
QC	Memo								
Quality Control									

DAS  
28  
9-88

*Handwritten:* 67x 13-12-18  
 J/RM 13/12/18  
 CL 13/12/18



# Picklist Print

Wednesday, September 11, 2013 7:43:36 A

Page 1 / 1

Work Order ID: 106617

Parent Item: 647.0115

Parent Item Name: Clip

Start Date: 9/11/2013

Required Date: 10/4/2013

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS  
MADE AT GFI DD VERF:JLM

IPP REV:B 13.09.10 NOW

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.0115P Clip		Purchased	No				Each	0.0000		100			

P-13/12/2 (87)



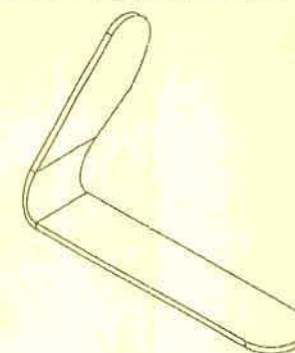




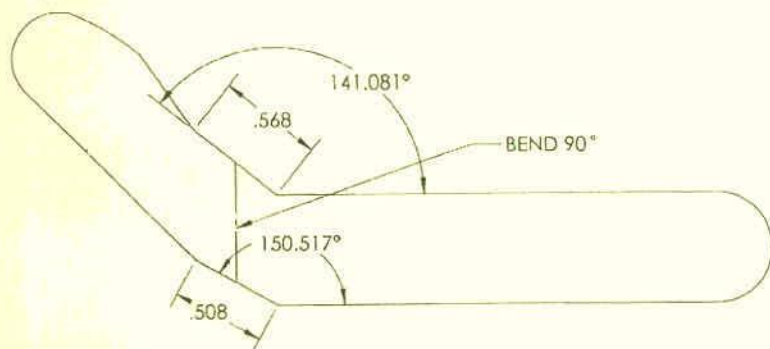
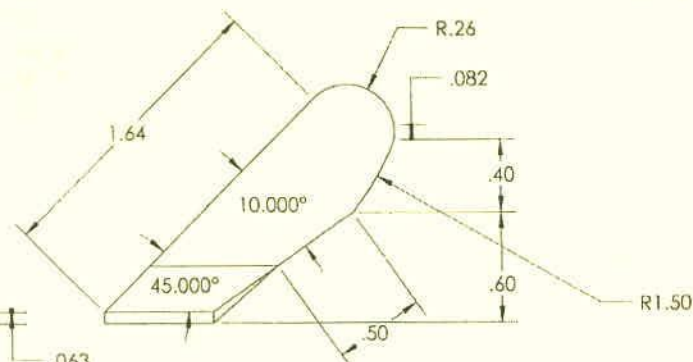
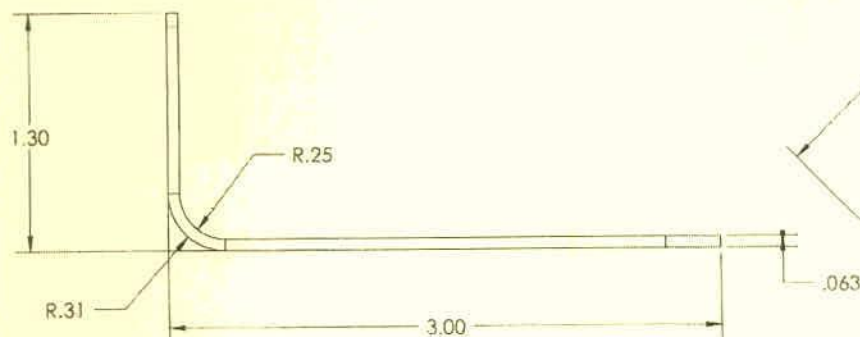
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

CD 13/09/11  
W 10' 106617



647.0114 SHOWN  
647.0115 OPPOSITE



FLAT PATTERN

OFFICIAL DATE 10/10/11 DRAWN BY R. RETLAND CHECKED P. BRAVO DRAWING APPROVAL P. BRAVO CONTRACT NO.		<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 1 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°		<b>SHEETMETAL</b> SHEET CODE 07M26 DWG NO. <b>647.0100</b> SCALE NONE	
REV. A		SHEET 5 OF 6	





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO21295

Purchase Order Date 9/11/2013

PO Print Date 9/11/2013

Page Number 1 of 1

Order From :

VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
6/13/2011

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 630 4877	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
Ship Via:	FedEx PI collect	FOB	Destination-Collect
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	647.0114P *	Clip	10/11/2013 Yes 10/11/2013		100.00 Each	\$6.00	\$600.00
AS PER DWG 647.0114 REV. A B106616							
Line Total:							\$600.00
2	647.0115P	Clip	10/11/2013 Yes 10/11/2013		100.00 Each	\$6.00	\$600.00
AS PER DWG 647.0115 REV. A B106617							
Line Total:							\$600.00
PO Total:							\$1,200.00

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.  
No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required ☒ YES ☐ NO  
PST# 6122-5207

Change Nbr:

1

Change Date: 9/11/2013







180 AVENUE LABROSSE  
POINTE-CLAIRE, QC, CANADA H9R 1A1  
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



# BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / DELIVERY DATE					N° DE BON DE LIVRAISON / SHIPPING MEMO NO	PAGE
11	10	13			0523022	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB#	VOTRE N° DE COMMANDE / YOUR ORDER NO	EXPÉDIÉ PAR / SHIP VIA
DART	GFI-0299	0274122	PO21295
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO	DESCRIPTION	

100 647.0115P

CLIP

ITEM 2  
C OF C REQ'D

MFG. JOB# J0274122-001 QTY 100 pcs

DUE DATE: 08 October 2013



EXPÉDITEUR / SHIPPER	N° DE BON DE LIVRAISON / SHIPPING MEMO NO
----------------------	---



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.





# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	1	OUR JOB NO	J0274122	SHIPPING MEMO	0523022
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
2	100 PCS	PO21295	647.0115P	A	CLIP
				DWG ISSUE	
				A	
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
AL 2024-T3 (AMS-QQ-A-250/4)		SAMUEL / KAISER ALUMINUM		650491A4	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	NO FINISH AS PER E-MAIL ATTACHED		
3	REF. GFI MANUFACTURING JOB NUMBER J0274122-001 (100 PCS)		
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **15 OCTOBER 2013**

G.F.I. Q.C. REP.







Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2008 + AS9120A

**LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE**

**Date:** September 27, 2013

**Company Name:** GFI Division of Thomas & Betts limited  
**Address:** 180 avenue Labrosse  
**City:** Pointe-Claire, Qc  
**Zip Code:** H9R 1A1

**# du client:** 83043  
**Customer's order #:**

**# de commande SSMQ:** 017058  
**SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	4	.063" X 48" X 144"	2024 T3	AMS-QQ-A-250/4	650491A4

*Bien à vous,  
Yours truly,*

*Kayla Vongeruen*





## SHIP TO:

SAMUEL BAIE D'URFE(SHIP TO)  
21525 CLARK-GRAHAM  
BAIE D'URFE, PQ, CA H9X 3T5

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4305992

## SOLD TO:

SAMUEL LAVAL  
2225 FRANCIS HUGHES  
LAVAL, PQ, CA H7S1N5

CUSTOMER PO NUMBER: C67160		WORK PACKAGE:		CUSTOMER PART NUMBER:		SHIP RUN/LOAD: 102704/2		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1156898	LINE ITEM: 3	SHIP DATE: 8-AUG-2013	ALLOY: 2024	CLAD: BARE	TEMPER: T3	PRODUCT DESCRIPTION: HT Flat Sheet			
WEIGHT SHIPPED: 2913 LB	QUANTITY: 65 PCS EST.	TRUCK B/L #: 2043467	GAUGE: 0.0630 IN (1.6002 MM)		DIAMETER/WIDTH: 48.000 IN (1219.2 MM)		LENGTH: 144.000 IN (3657.6 MM)		

MHU 1705468: LOT 650491A4: 65 pieces; **D944024**

### Certified Specifications

AMS 4037/RevP  
CMMP 019/RevD

AMS-QQ-A-250/4/RevA  
CMMP 025/RevU

ASTM B 209/Rev10

Test Code: 1504

### Test Results

Lot: 650491A4 Cast 630

Drop 12

Ingot 2

Melted in USA

(ASTM E8/B557)  
(EN 2002-1)

Tensile: Temper  
T3

Dir / # Tests  
LT / 2 (Min:Max)

Ultimate KSI (MPA)  
68.5 : 68.8  
(472 : 474)

Yield KSI (MPA)  
44.8 : 45.9  
(309 : 316)

Elongation %  
19.0 : 19.4

(ASTM E1251)

Chemistry:  
Actual(wt%)

SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
0.13	0.21	4.5	0.55	1.3	0.02	0.19	0.02	0.01	0.01	TOT 0.03

### ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024												
MIN(wt%)	0.00	0.00	3.8	0.30	1.2	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder









# KAISER ALUMINUM

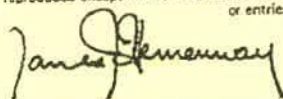
Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4305992

### CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser) hereby certifies that metal shipped under this order was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content. This material has been inspected, tested and found in conformance with the requirements of the applicable specifications as indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements. All metal which is solution heat treated complies with AMS 2772. Any warranty is limited to that shown on Kaiser's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of Kaiser Aluminum Fabricated Products, LLC laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law. ISO-9001:2000 certified.



JAMES HEMENWAY, LABORATORIES SUPERVISOR







Pedro Mendez &lt;pedro.mendez@tnb.com&gt;

rfq


Messages

**Linda Lacelle** <llacelle@dartaero.com>  
To: Pedro Mendez <pedro.mendez@tnb.com>

Tue, Sep 10, 2013 at 8:47 AM

Hi Pedro,  
Could you please advise price and delivery on 647.0114 & 647.0115 per attached.  
Qty's of 50 or 100

Thx  
Linda

 **647.0100 A Sheetmetal.pdf**  
1783K

**Pedro Mendez** <pedro.mendez@tnb.com>  
To: Linda Lacelle <llacelle@dartaero.com>

Tue, Sep 10, 2013 at 11:52 AM

Hi Linda for the finishing we do or Dart take care?

[Quoted text hidden]

**Pedro Mendez**  
*Représentant technique*  
*Technical Sales Representative*  
**Thomas & Betts Manufacturing Inc. - GFI Division**  
180 Avenue Labrosse, Pointe-Claire  
Quebec, Canada H9R 1A1

 (514) 630-4877- EXT 228  
 (514) 630-4849  
Email: pedro.mendez@tnb.com





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<http://groupwise.tnb.com/disclaimer/>

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**Linda Lacelle** <[llacelle@dartaero.com](mailto:llacelle@dartaero.com)>  
To: Pedro Mendez <[pedro.mendez@tnb.com](mailto:pedro.mendez@tnb.com)>

Tue, Sep 10, 2013 at 11:51 AM

We can take care of all the finishing...thx

**From:** Pedro Mendez [<mailto:pedro.mendez@tnb.com>]  
**Sent:** September-10-13 11:53 AM  
**To:** Linda Lacelle  
**Subject:** Re: rfq

[Quoted text hidden]

<http://disclaimers.tnb.com/disclaimer/email/>

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**Pedro Mendez** <[pedro.mendez@tnb.com](mailto:pedro.mendez@tnb.com)>  
To: Linda Lacelle <[llacelle@dartaero.com](mailto:llacelle@dartaero.com)>

Tue, Sep 10, 2013 at 1:50 PM

Hi Linda

50 pcs 8.00\$each 100 = 6.00\$each 200 = 5.00\$each (even if you order 100 of each) 4 weeks delivery cad file required not finishing,

Regards

On Tue, Sep 10, 2013 at 8:47 AM, Linda Lacelle <[llacelle@dartaero.com](mailto:llacelle@dartaero.com)> wrote:  
[Quoted text hidden]

—  
**Pedro Mendez**  
*Représentant technique*





A.T.G. Industries Inc.  
731, rue Industrielle Rd.  
PLATING DEPARTMENT  
Rockland, On K4K 1T2  
Canada  
Ph: (613) 446-4544  
Fax: (613) 446-4556

### Pack List

Number: 62748

Date: 20-Nov-13

To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ship To


DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
52 ea	Part: 647.0114  (6.45) HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2  PRIME MIL-P-23377J TYPE I CLASS N  PRICE IS PER PIECE Job: 20130706	Rev:	PO: 21743 Line:
71 ea	Part: 647.0115  (6.45) HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2  PRIME MIL-P-23377J TYPE I CLASS N  PRICE IS PER PIECE Job: 20130707	Rev:	PO: 21743 Line:
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : <u>20/11/13</u></p> <p>CERTIFIED SIGNATURE : <u></u></p> <p>RECEIVER SIGNATURE : _____</p>			





NCR: ☒ Yes ☐ No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Arch Date: 14/01/02QA Closed: AT Date: 13/12/27

Work Order: <u>106617</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>1047.0115</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-3382</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input checked="" type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	13/12/17	170	4	part lost in receiving Qty ④ RC: Engineer Error	J 05742 13/12/27	lost part no replace  \$13.05	C2 13/12/17	DAS 27 9-89 13/12/17	DAS 27 9-89 13/12/17
Equip/Tooling									
Operator									
Material									
Setup									
Other <input checked="" type="checkbox"/>									
Process									
Supplier									
Training									
Unapproved									

## FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

303  
31  
DVB